Date; User: Monday, 7/30/2007 1:53:59 PM

kim Johnston

**Process Sheet** 

Customer Job Number : CU-DAR001 Dart Helicopters Services

**Estimate Number** 

: 11927

P.O. Number

: NIA

This Issue Prsht Rev. : 7/30/2007

S.O. No. : NA

Type

: MACHINED PARTS

**Drawing Number** Project Number **Drawing Revision** 

Material Due Date

**Drawing Name** 

**Part Number** 

: N/A : E

: 8/20/2007

: RESTRICTOR

D2005003 REV E

: D2005003

Each

Previous Run Written By Checked & Approved By

First Issue

Comment

: Est

F63.04.30

Reformat: Made on Cobra KJ/RF

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M303R0500

303 Round Bar 0.500"



Comment: Qty.:

0.0547 f(s)/Unit Total:

0.2735 f(s)

303 Round Bar 0.500"

Material: Ø1/2" AISI 303 Round Bar (M303R0.500) or Ø7/16" AISI 302/304 SS Round Tubing 0.065" wall

(M304TR0.375W.065) Batch M 196292

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Turn blank as per Folio FA275

Deburr

3.0 QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

PACKAGING 1

PACKAGING RESOURCE #1

5.0

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:\_\_\_\_

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES							
DATE STEP		PROCEDURE CHANGE By					Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			1						
:									
Part No	):	PAR #: Fault Category:	NC	R: Yes	No) DQ	A: <u></u>	Date:	Malle	

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:			WORK ORDI	ER NON-CONFORMANC	E (NCR)	R)					
	11.	Description of NC		Corrective Action Section B		Varification	Ammanual	<b>A</b>			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
		_						. 3			

NOTE: Date & initial all entries

Date:

Monday, 7/30/2007 1:53:59 PM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RESTRICTOR

Job Number: 33793

Part Number: D2005003

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mi roorlielich

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
÷										
Part No	:	PAR #: Fault Category: NC	R: Yes	No DQA	<b>\</b> :	Date:				

Part No:	PAR	R#: Fault Catego	ry:	NCR: Yes	No DQ	A:	Date:
				QA:	N/C Close	d:	Date:

NCR:		V	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Approval QC Inspector		
DATE	STEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C				
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						24		`		

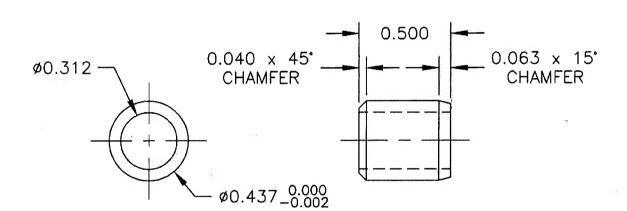
NOTE: Date & initial all entries





DESIG	и JB	DRAWN BY	DART AEROSPACE LTE HAWKESBURY, ONTARIO, CANADA	)
CHEC	KEDN	APPROVED	DRAWING NO.	REV. E
	4	1	D2005-003 SHEE	ET 1 OF 1
DATE			TITLE	SCALE
 03.0	05.01		RESTRICTOR	2:1
O		96.04.17	REDRAWN	
۵		97.09.03	304 S.S. SPEC ADDED	
Ε		03.05.01	ADDED TOLERANCE TO Ø0.437	





## NOTE:

1) MATERIAL: Ø0.50 AISI 303 ROUND BAR (REF DART SPEC.

M303R0.500) OR Ø0.435 AISI 302/304/316 SS 0.065

WALL SEAMLÉSS ROUND TUBING (REF. DART SPEC.

M304TR0.375W.065)

SHOP COPY RETURN TO

2) FINISH: NONE

ENGINEERING 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE CHORED COPY

4) ALL DIMENSIONS ARE IN INCHES

SUBJECT TO AMENDMENT

5) BREAK ALL SHARP EDGES 0.005 TO 0.010

WITHOUT NOTICE

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DART AEROSPACE LTD	Work Order:	33793
0		<u> </u>
Description: PUSTRICTOR	Part Number: Da	2005-003
		5 4 64
Inspection Dwg 705-003 Rev:		Page 1 of 1

<u> </u>	FIRST A	ARTICLE IN	SPECTIO	ON CHE	CKLIST	
·		First Artic	le _	Proto	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
-312	t/ 1010	1315				
- 437	002	1436				
- 500	-,002 +1-,010 +1-,010 +1.5 +1-,010 +1.5	1501				
.040 ×450	+/- 1010 4,5	1935 x45				
063×15°	th. 010 th. 5	.062 × 15°				
					,	
	,					
		-				
						val:
Measured by:	A P	Audited by:	J.F.		Prototype Appro	
Date:	7/8/07	Date:	07/12/	07		ate:
Date Date	Change			<del></del>	Rev	ised by Approved

Measu	ired by:		Audited by:	Flototype Approvair	
	Date:	07/0/07	Date: 07/12/07	Date:	
Rev	Date	Change		Revised by	Approved
Kev	Date	Change	,	14 UDE	
Α		New Issue		KJ/RF	

